

Work Order ID 72843

Tuesday, August 16, 2011 10:05:49 AM



Page 1

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 8/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-08-18*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-511

CHG004

8 11/08/17

11-08-16 (2)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/16 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Accept

Setup Start

Revision ID:

Stop

Item Name: saddle kit 642-511

Start Date: 8/16/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 8/18/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

S ulas/17



QC

Memo

0.00

Quality Control

130

Packaging

0.00

RK



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-511 Location: _____

R603

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-88-17
②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 1

Work Order ID: 72843

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 07.06.05 new issue EC
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A BOLT		Purchased	No			110	Each	61.0000	3	6			

Location Loc Qty Loc Code

FG	4	
18914	4	
ST352	20	
117366	20	
ST353	37	
114523	12	
117872	25	

AN3C36A BOLT		Purchased	No			110	Each	131.0000	9	18			
-----------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

Location Loc Qty Loc Code

FG	14	
101261	4	
116590	10	
FP-B	27	
111925	27	
ST303	8	
116590	8	
ST353	82	
100771	12	
118191	50	
118451	20	

11/16/10 2x

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C41A

Purchased

No

110

Each

113.0000

8

16

BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

109

117950

59

118518

50

AN4C6A

Purchased

No

110

Each

409.0000

12

24

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

405

116704

19

117619

9

117794

2

117872

75

118191

100

118451

200

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72843

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

Sp AN5C11A
Bolt

Purchased No

110 Each

134.0000

8

16

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

60

117872

60

ST338

70

117094

20

118191

50

Sp AN5C12A
BOLT

Purchased No

110 Each

87.0000

4

8

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

85

117313

35

118451

50

Sp AN5C13A
BOLT

Purchased No

110 Each

104.0000

4

8

Location

Loc Qty

Loc Code

FG

4

18918 X

4

ST338

100

117313

50

117872

50

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

AN5C15A

Purchased

No

110

Each

100.0000

1

2



Bolt

Location

Loc Qty

Loc Code

ST338

23

118191

23

ST339

77

117764

2

117885

25

118267

50

AN5C32A

Purchased

No

110

Each

101.0000

2



Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

97

116380

47

117407

25

117969

25

AN5C34A

Purchased

No

110

Each

56.0000

2



Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

54

112454

4

117763

25

117950

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

AN5C35A

Purchased

No

110

Each

66.0000

1

2



Location

Loc Qty

Loc Code

ST340

41

108407

41

ST341

25

118451

25

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

0.0000

24

48



washer

AN960C416L

Purchased

No

110

Each

0.0000

24

48



WASHER

AN960C516L

NAS1149C0532
R

Purchased

No

110

Each

0.0000

8

16



WASHER

D206-648-013

CH67002

Manufactured

No

110

Each

5.0000

1

2



GHW Modification

Location

Loc Qty

Loc Code

FG120

5

71577

3

71578

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 72843

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

8a D2652
Bushing

Manufactured No

110

Each

399.0000

16

Location

Loc Qty

Loc Code

FG

44

31985

44

ST

201

53741

0

72120

201

ST019

154

71833

154

8a D2712
Set Screw

Manufactured No

110

Each

581.0000

10

20

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

531

71160

231

72231

300

0a D2932-1
Saddle LH Out, 206

Manufactured No

110

Each

10.0000

1

2

Location

Loc Qty

Loc Code

ST428

10

69922

6

70874

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72843

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

S D2933-1
Saddle LH In, 206

Manufactured No

110 Each

9.0000



1

Location

Loc Qty

Loc Code

ST421

1

71062

1

ST428

8

69926

4

70875

4

S D2934
Saddle Spacer

Manufactured No

110 Each

43.0000



2

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

37

70772

37

S D2935
Saddle Spacer

Manufactured No

110 Each

35.0000



2

Location

Loc Qty

Loc Code

ST027

35

70770

35

S D2938-1
Saddle LH Out, 206

Manufactured No

110 Each

9.0000



1

Location

Loc Qty

Loc Code

ST428A

9

69918

3

70862

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 72843

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

D2939-1

Manufactured No

110

Each

6.0000

1

2



Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

1

71056

1

ST428A

5

69927

5

D3396-3

Manufactured No

110

Each

25.0000

2



Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

15

70983

15

D3407-043

Manufactured No

110

Each

3.0000

1

2



Tow Ring

Location

Loc Qty

Loc Code

ST463

1

72513

1

ST464

2

68339

2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72843

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

Sa D3456-1
Washer

Manufactured No

110 Each

60.0000

1 2
\$

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

53

66848

3

71165

50

Manufactured No

110 Each

66.0000

2 4
\$

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

56

67779

1

71849

55

Manufactured No

110 Each

1,316.000

24 48
\$

Sa D3672-1
Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1314

64177

318

66821

496

72229

500

ST077

2

52505

2

4/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

S
+2 D3672-3
Phenolic Washer

Manufactured No

110 Each

887.0000

24 48

Location

Loc Qty

Loc Code

ST074

887

64176

225

71159

162

~~72230~~

500

Manufactured No

110 Each

534.0000

24 48

Location

Loc Qty

Loc Code

ST074

534

53237

244

64175

290

S
MS21043-3
Nut

Purchased No

110 Each

1,038.000

20 40

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

966

~~112314~~

6

~~118077~~

460

~~118614~~

500

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72843



Parent Item: K642-511



Parent Item Name: saddle kit 642-511

Start Date: 8/16/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

110

Each

969.0000

13

26



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

929

117793

482

118378

447

MS21043-5

Purchased

No

110

Each

524.0000

4

8



Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

404

112314

304

116548

100

ST314

100

118159

100

26
8
SP

11/8/16 SP 20

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4				AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8				AN960C516L	* WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130 (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	* INSERT ⁽¹⁾
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

continued on next page...

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continued from previous page...

ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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